

Work Order ID 147743

June 10, 2016 12:00:33 PM

147743

Page 1

Item ID: D212-664-201TRN Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Crosstube Turning Detail
 Start Date: 6/10/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/24/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: 54 Date: 6/10/16 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D212-664-241	Rev E								

100

0.05

100

Mori Seiki

Mori Seiki CNC Lathe Large

MORI SEIKI CNC LATHE LARGE

Memo

0.16

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA114

2-Turn first side as per Folio FA114

3-Blend transition lines only, **do not sand whole tube**:

FOLIO REV: AD

DWG REV: E

*Use mill bastard file, brush file repeatedly with file card.

*Do not use sandpaper coarser than 320 grit.

1 Ø 16/6/14

DAS
49
9-89

110

QC1- Inspection performed by CMM

0.00

110

QC

Quality Control

Memo

0.00

1 Ø 16/6/14

DAS
49
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____ Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									

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147743

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	MORI SEIKI CNC LATHE LARGE	0.00				1	0		UHF 16/6/14
120									
Mori Seiki	Memo	0.32							
Mori Seiki CNC Lathe Large	1-Turn second side as per Folio FA114								
	2-Blend transition lines only, **do not sand whole tube**: *Use mill bastard file, brush file repeatedly with file card. *Do not use sandpaper coarser than 320 grit. FOLIO REV: <u>AD</u> DWG REV: <u>E</u> 3-Remove sand and plugs								DAS 49 9-89
	4- scribe batch # and part # as per dwg								
130	QC1- Inspection performed by CMM	0.00					1	0	UHF 16/6/14
130									
QC	Memo	0.00							
Quality Control									
									DAS 49 9-89

DAS
49
9-89

DAS
49
9-89

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 147743***147743***

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June 10, 2016 12:00:33 PM

Item ID: D212-664-201TRN

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Crosstube Turning Detail

Stop ***NS2***

Start Date: 6/10/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/24/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

QC8- Inspect parts - second check

0.00

140

QC

Memo

0.00

Quality Control

DAS

47~~9-80~~

16-06-17

145

0.00

145

Crosstubes

Memo

0.10

Crosstubes

GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.

DP 16-6-22
2/1/16

150

0.00

150

HandFXtube

Memo

0.09

Hand Finishing Crosstubes

1- PRESSURE WASH X-TUBE INSIDE AND OUT

2- ALODINE AND ACID ETCH X-TUBE INSIDE AND OUT. USE RED
SCOTCH BRITEDP 16-6-27
2/1/16

DQA: _____ Date: _____

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Work Order update only ☐

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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
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Required Date: 6/24/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

Quality Control

DAS

38

9-88

JUN 28 2016

170

Packaging

0.00

170

Packaging

Memo

0.00

Packaging

Identify and stock in kanban rack

Location: 15014

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.02

Quality Control

Df 16-6-20
The

16/6/29 JJ

SH 6/29/16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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								Lead hand / Supervisor Approval Verification	
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

June 10, 2016 12:00:37 PM

147743

D212-664-201TRN

Start Date: 6/10/2016

Required Date: 6/24/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-03-06 new issue DD verified by:ec
IPP Rev B 08.04.02 Removed polish EC verified DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6006-129		Manufactured	No			120	Each	76.0000	1	1			

D6006-129

Crosstube Material

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG003	41	
107875	18	
107876	2	
123969	21	
SHED	35	
123967	18	
139422	17	

DAS
49
3-89

Item	Qty -241	Qty -241B	Part Number	Description
1	X		D212-664-241	CROSSTUBE ASSEMBLY (205/212 HIGH AFT)
2		X	D212-664-241B	CROSSTUBE ASSEMBLY (214 HIGH AFT)
3	1	1	D6006-129	CROSSTUBE
4	2		D2940-1	SUPPORT
5	4	4	D3595-063-530	RUBBER CUSHION
6		2	D5018-1	SUPPORT
7	4	4	MS21920-28	CLAMP (OR MS21920-30)
8	A/R	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

GENERAL NOTES:

- MATERIAL: MANUFACTURED FROM D6006-129
FINISHED LENGTH = 124.362±0.020
- FINISH: a) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
b) PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
c) MASK UNDERSIDE OF CROSSTUBE AS SHOWN (ZN C6-2 / C6-3, HATCHED AREA)
d) PAINT OUTSIDE PER DART QSI 005 4.2
e) REMOVE MASKING AND APPLY MATTE CLEAR COAT
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER 'D212-664-XXX' AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- WEIGHT: D212-664-241/-241B = 44.2 lbs
- PART IS SYMMETRIC ABOUT CENTERLINE.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

MACHINING

- RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.

BENDING

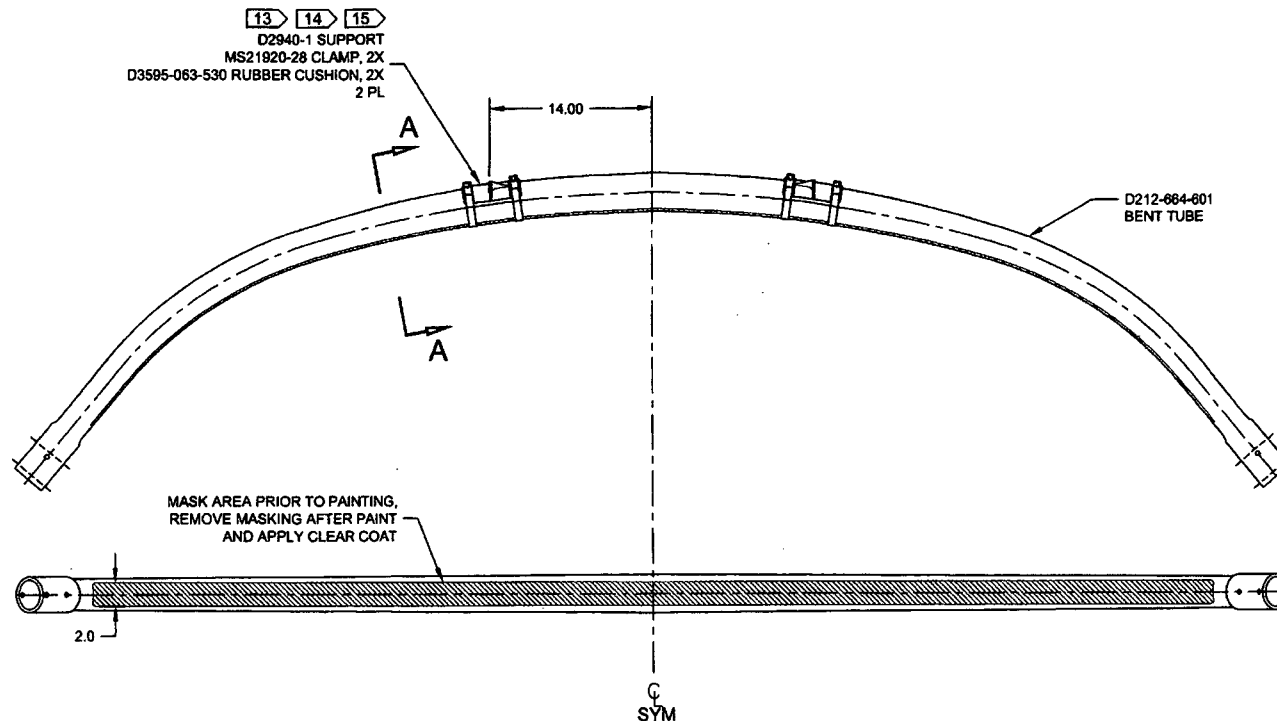
- BEND PROGRESSIVELY WITH A MINIMUM OF 5 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 7.2% (BASED ON O.D.) IN LOWER HALF OF R35.5 BEND AND 6% (BASED ON O.D.) ON REMAINING TUBE.
- LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.

ASSEMBLY

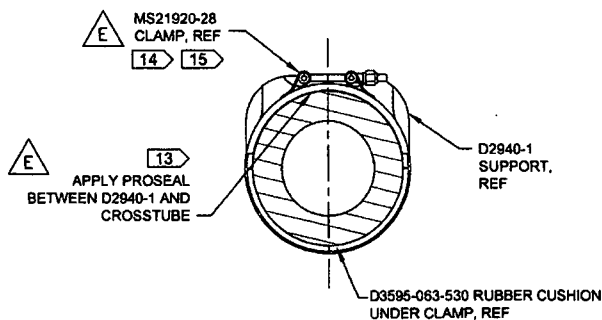
- INSTALL D2940-1 / D5018-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- INSTALL MS21920-28 CLAMPS (OR -30) WITH D3595-063-530 RUBBER CUSHIONS TO SECURE THE SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE ON TOP SIDE OF CROSSTUBE.
- TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.

E	D5018-1 WAS D2940-1 (-241B), PROSEAL WAS MAGNOBOND. NOTE 2: ADD INSPECTION WINDOW, NOTE 11: ALLOW 7.2% CRUSH, NOTE 15: ADD 72HR CURE AND RETORQUE FOR PROSEAL, ADD SHEET 3, CLAMPS REVERSED TO PREVENT CHAFING (ZN B7-2, B7-3), BEND HEIGHT TOL. NOW 0.25 WAS 0.13 (C1-4), INCORP DEO D-1/-2	CP	14.04.01
D	REFORMAT/REVISE GENERAL NOTES/PART LIST; REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; ADD -241B (ZN D4-2, B4-2); REMOVED REF & ADD TOLERANCES (ZN D8-3 & C4-3, C6-3 & A8-3); RELOCATED FLAG #6 PER PAR 08-048 (ZN A5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4	RF	09.09.30
C	REMOVE -1009 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	PH	07.03.08
B	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	CP	00.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	14.04.01		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D212-664-241	REV. E SHEET 1 OF 5
TITLE CROSSTUBE ASS'Y (205/212 HI AFT)	SCALE NTS
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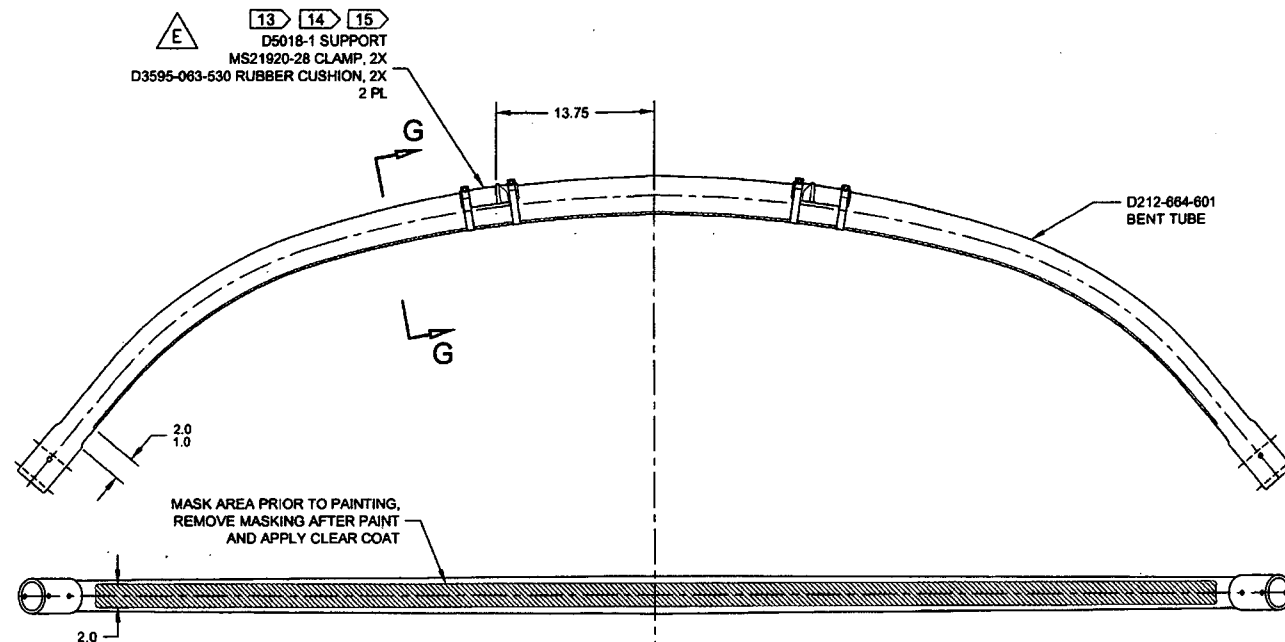
**D212-664-241
ASSEMBLY DETAIL**



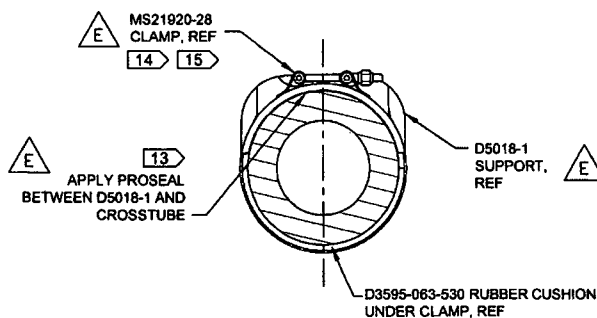
**SECTION A-A
SCALE 4X**

RELEASED
2014-05-26
MND

DESIGN	Q	DART AEROSPACE LTD	
DRAWN	Q	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DL	DRAWING NO.	REV. E
MFG. APPR.	MP	D212-664-241	SHEET 2 OF 5
APPROVED	MP	TITLE	SCALE
DE APPR.	H	CROSSTUBE ASS'Y (205/212 HI AFT)	NTS
DATE	14.04.01	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



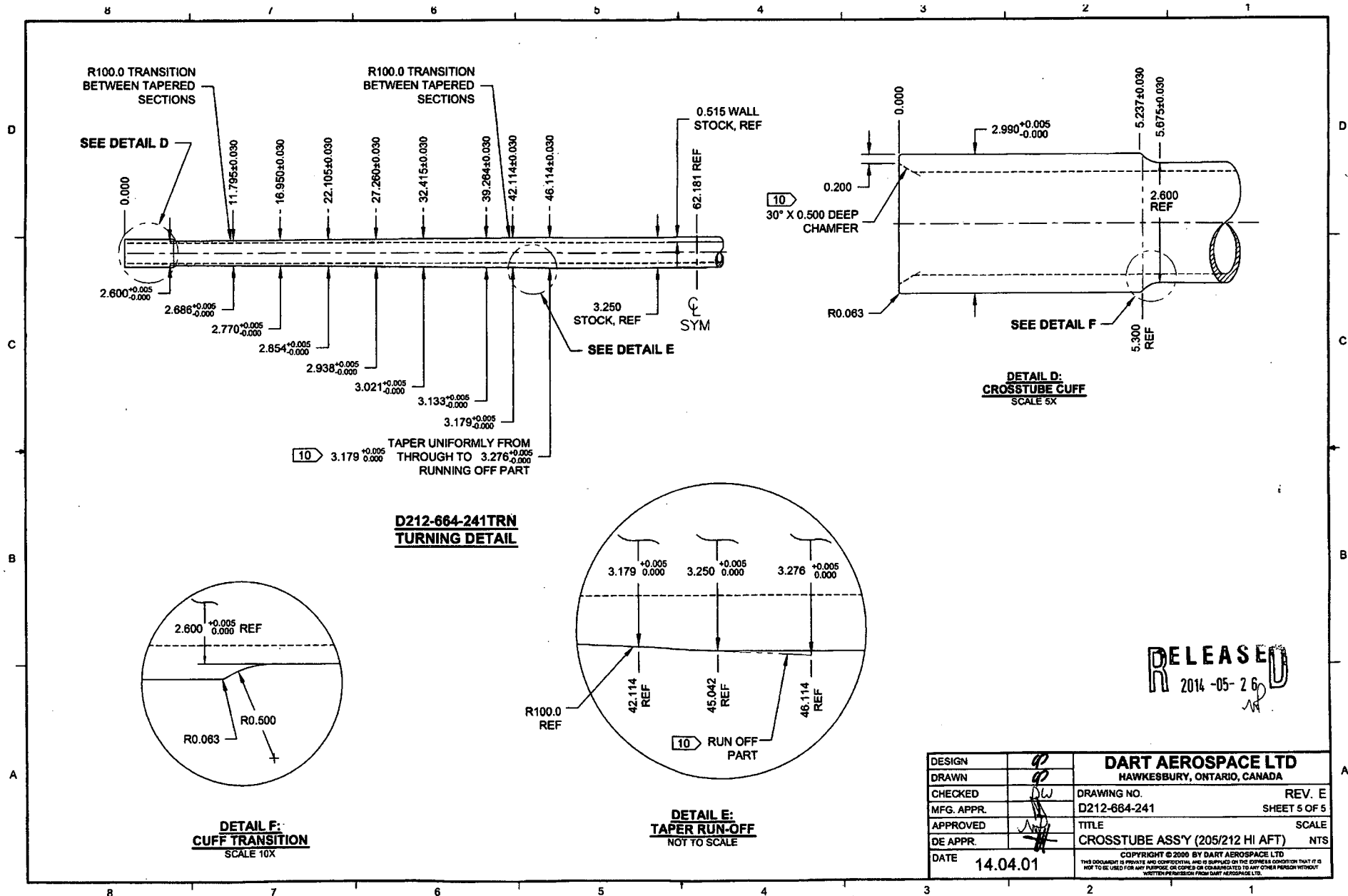
D212-664-241B
ASSEMBLY DETAIL



SECTION G-G
SCALE 4X

RELEASED
2014-05-26
MD

DESIGN	92	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DW	DRAWING NO.	REV. E
MFG. APPR.	10	D212-664-241	SHEET 3 OF 5
APPROVED	10	TITLE	SCALE
DE APPR.	10	CROSSTUBE ASS'Y (205/212 HI AFT)	NTS
DATE	14.04.01	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



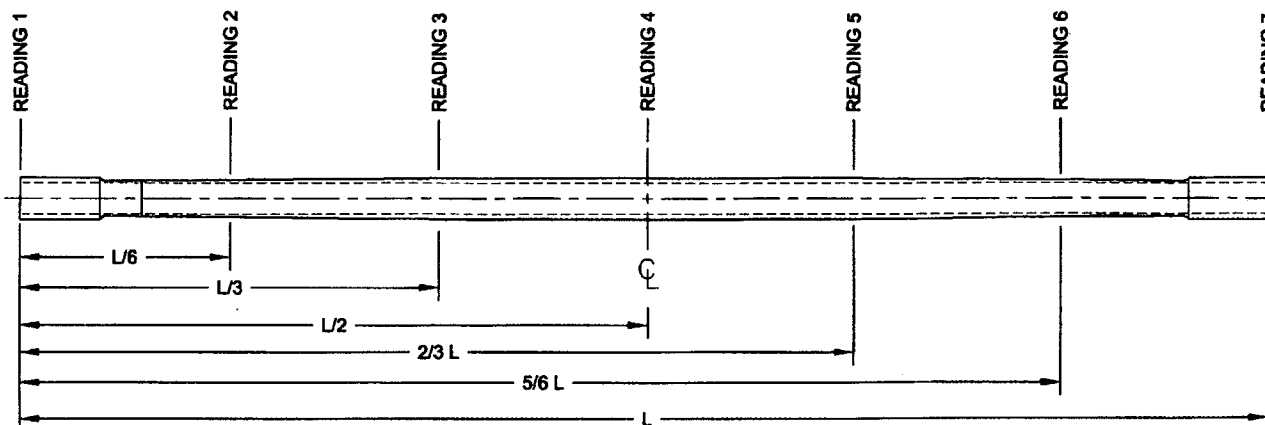
DART AEROSPACE LTD	Work Order:	<i>147743</i>
Description: Crosstube Assembly (205/212 High Aft)	Part Number:	D212-664-241
Inspection Dwg: D212-664-241 Rev: E		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.200	+/-0.010	<i>0.200</i>	✓			
	R0.063	+/-0.010	<i>0.063</i>	✓			
	2.990	+0.005/-0.000	<i>2.993</i>	✓			
	5.237	+/-0.030	<i>5.237</i>	✓			
	2.600	+0.005/-0.000	<i>2.605</i>	✓			
	2.686	+0.005/-0.000	<i>2.691</i>	✓			
	2.770	+0.005/-0.000	<i>2.775</i>	✓			
	2.854	+0.005/-0.000	<i>2.858</i>	✓			
	2.938	+0.005/-0.000	<i>2.941</i>	✓			
	3.021	+0.005/-0.000	<i>3.026</i>	✓			
	3.133	+0.005/-0.000	<i>3.135</i>	✓			
	3.179	+0.005/-0.000	<i>3.182</i>	✓			
SIDE B	0.200	+/-0.010	<i>0.200</i>	✓			
	R0.063	+/-0.010	<i>0.063</i>	✓			
	2.990	+0.005/-0.000	<i>2.994</i>	✓			
	5.237	+/-0.030	<i>5.237</i>	✓			
	2.600	+0.005/-0.000	<i>2.605</i>	✓			
	2.686	+0.005/-0.000	<i>2.741</i>	✓			
	2.770	+0.005/-0.000	<i>2.774</i>	✓			
	2.854	+0.005/-0.000	<i>2.857</i>	✓			
	2.938	+0.005/-0.000	<i>2.941</i>	✓			
	3.021	+0.005/-0.000	<i>3.026</i>	✓			
	3.133	+0.005/-0.000	<i>3.136</i>	✓			
	3.179	+0.005/-0.000	<i>3.182</i>	✓			
	124.362	+/-0.020	<i>124.362</i>	✓			
				✓			

DART AEROSPACE LTD	Work Order:	147743
Description: Crosstube Assembly (205/212 High Aft)	Part Number:	D212-664-241
Inspection Dwg: D212-664-241 Rev: E		Page 2 of 2

WALL THICKNESS MEASUREMENT



Location	WALL THICKNESS MEASUREMENT (IN)				Deviation Δw (max-min)	TOLERANCE
	w1	w2	w3	w4		
READING 1 L= 0"	.415	.403	.386	.395	0.029	0.062"
READING 2 L= 20.727	.320	.347	.319	.301	0.046	
READING 3 L= 41.454	.492	.499	.483	.483	0.016	
READING 4 L= 62.181	.532	.527	.525	.533	0.008	
READING 5 L= 82.908	.506	.494	.475	.491	0.031	
READING 6 L= 103.635	.352	.335	.285	.312	< 0.067	
READING 7 L= 124.362	.404	.398	.394	.409	0.015	

Dwg

△

6.306 6.024

DAS
19
89

6K DAS
12
9-89 16/6/17 DAS
47
9-89

Calibration Result

Actual Block Thickness: 500-7500

Sitescan 250 Measured Thickness: 500-750

Measured by: [Signature]	Audited by: [Signature]	Preliminary Approval:
Date: 16/6/14	Date: 16-06-17	Date:

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue (P/O D412-664-201)	KJ/JLM	
B	06.03.09	Tolerance for 5.237 was +/-0.001	KJ/JLM	
C	07.05.08	Dwg Rev. updated	KJ/JLM	
D	10.08.03	Dimension 124.362 was 124.36	KJ	
E	12.06.04	Wall thickness form added	KJ	
F	15.03.03	Dwg Rev updated	KJ	